

ABSTRACT OF THE DISCLOSURE

An improved apparatus used in press brakes having a lower
5 press member and an upper press member which are movable relative
toward and away from each other for bending and forming sheet
materials is provided. The apparatus includes a die base, first and
second mobile carrier shoes, a plurality of spacer bars, and a pair
of anvils. Each one of the pair of anvils is formed with four
10 corners each having a separate and distinct radius of curvature so
as to define four alternative forming surfaces. Each one of the
anvils are selectively rotatable so that one of the four corners
having the same radius of curvatures are on top and facing inwardly
toward the other corresponding to first through fourth ones of the
15 four alternative forming surfaces and forming first through fourth
die-size openings therebetween used for bending and forming a
material of different predetermined gauges. As a result, multiple
bending operations with different gauges of sheet material can be
achieved without changing completely to a different lower die.